

Work Order ID 67591-2

Monday, March 28, 2011 11:43:07 AM



Page 1

Item ID: D3564-11

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 3/28/2011 Start Qty: 16.00

Required Date: 3/31/2011 Req'd Qty: 16.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date: 11-03-28

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3564

Rev D

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3564 \*\*\*\*\* (D3564-1F) \*\*\*\*\* Dwg Rev: D Prog

Rev: D 2-Deburr if necessary

11-4-4



110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

11-4-4

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

5/10/04



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Stop



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Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Brake NC

NC BRAKE

0.00

Memo

0.00

Brake NC

Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT8179

SB 11/04/06

16

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8 v/04/06

416

150



Large Fab

Large Fab

0.00

Memo

0.00

Large Fab

Qty Description Batch: A/R 2059B Hardcoat  
m118196 Weld hardcoat as per Dwg D3437

10 11-07-19 JBL/ea.

# Work Order ID 67591

Monday, March 28, 2011 11:43:07 AM

Page 3

Item ID: D3564-11

Revision ID:

Item Name: Wearshoe

Start Date: 3/28/2011 Start Qty: 16.00

Required Date: 3/31/2011 Req'd Qty: 16.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00

*S. W. 1/9*

QC

Memo

0.00

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00

*S. W. 1/9*

QC

Memo

0.00

Quality Control

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

*117838*

Memo

0.00

START TIME:

*2:20*

OVEN TEMPERATURE:

FINISH TIME:

*2:50*

Powdercoat

Powder Coating

*10 & BL 11-7-19*



# Work Order ID 67591

Monday, March 28, 2011 11:43:07 AM

Page 4

Item ID: D3564-11

Accept

Revision ID:

Item Name: Wearshoe

Start Date: 3/28/2011 Start Qty: 16.00

Required Date: 3/31/2011 Req'd Qty: 16.00

Reference:

Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

*Sup/20 (10)*

200

Identify as per dwg & Stock Location: *FP*

0.00



Packaging

Memo

0.00

Packaging

*Sup/20 (10)*

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*n/h/20*  
*MF*  
*11-07-20*

# Picklist Print

Page 1

Monday, March 28, 2011 11:43:12 AM

Work Order ID: 67591



Parent Item: D3564-11



Parent Item Name: Wearshoe



Start Date: 3/28/2011

Required Date: 3/31/2011

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A New Issue 07-03-08 ec  
 IPP Rev:B As per Rev C 07-07-09 JLM  
 IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC  
 IPP Rev:D Comments revised on Step 5, 6 per B44656 09-02-06 KJ  
 Verified By:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased		No		100	sf	4.0000	1.41	23.74737			
										113 11-4-4			
304/316 Sheet .063													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					MAT020	4		117 275					
					116623	4							
											(16)		



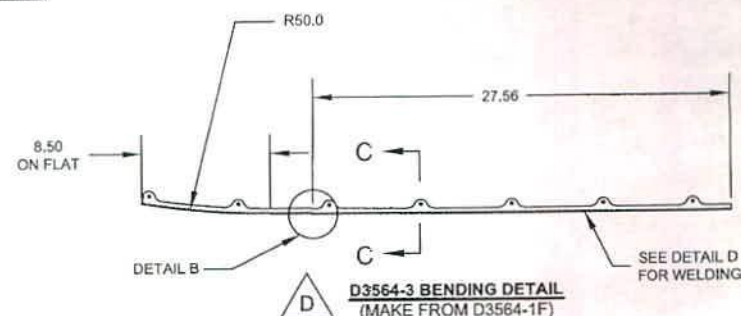
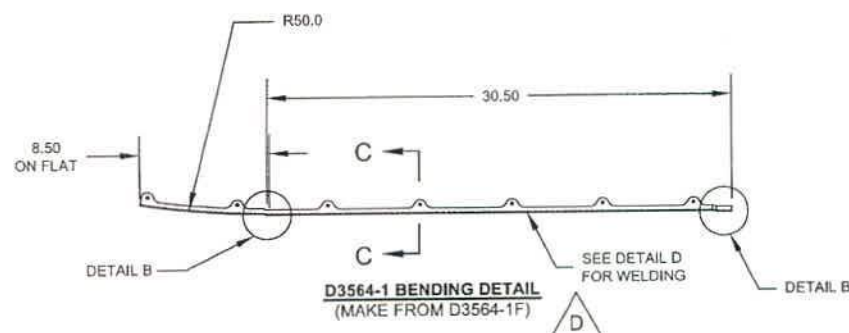


SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 07591  
PH 11-03-28

RELEASED

07.09.04 PH

D3564-1F FLAT PATTERN



D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT  $\bar{C}$

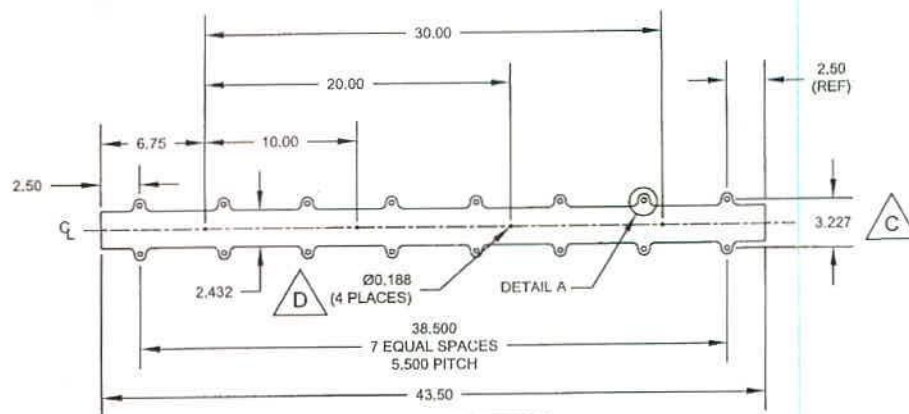
WEIGHTS:

D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

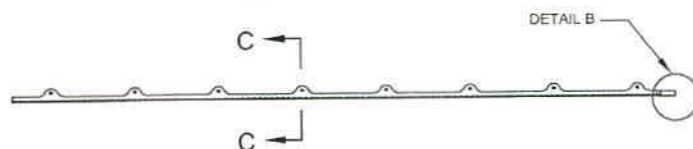
D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8; UPDATE NOTES; PG1 A8, PG3 B5,C5; ADD D3564-15; PG1 B6,B3; D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3; D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3; D3564-9/-11 WAS ON PG1; PG3 B8,C8; D3564-13 WAS ON PG2; PG3 D2; WELDING DETAIL WAS ON PG1; PG3 A5,7,B2; RELOCATE DETAILS AND SECTION; PG3 A5,7,B2; INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.08.21		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3564	REV. D SHEET 1 OF 3
TITLE WEARSHOE	SCALE 1:8

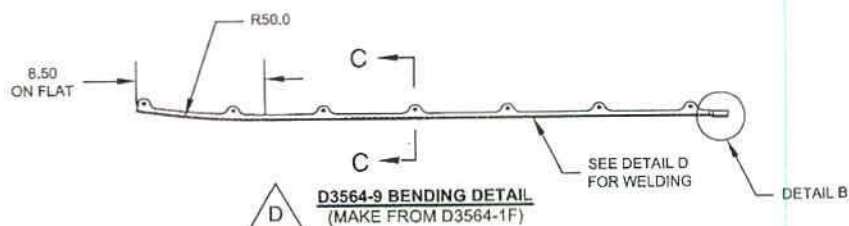
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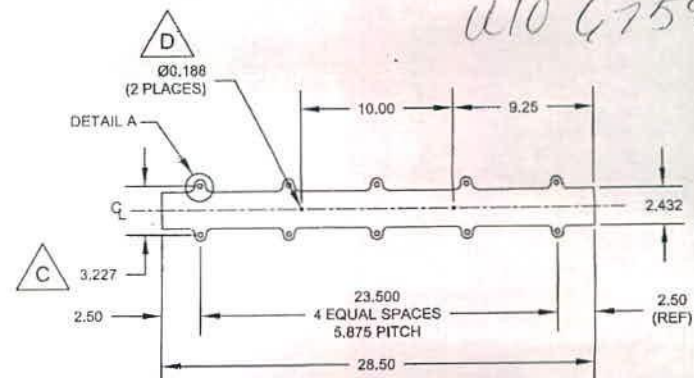
**D3564-5F FLAT PATTERN**



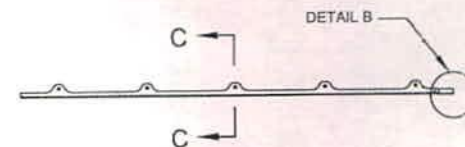
**D3564-5 BENDING DETAIL**  
(MAKE D3564-5 FROM D3564-5F)



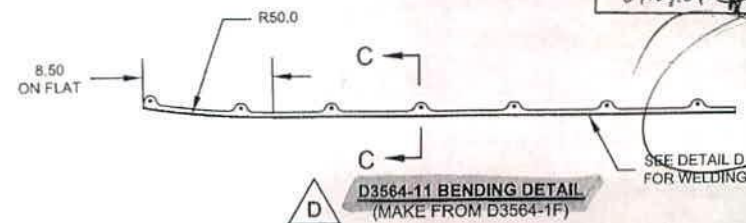
**D3564-9 BENDING DETAIL**  
(MAKE FROM D3564-1F)



**D3564-7F FLAT PATTERN**



**D3564-7 BENDING DETAIL**  
(MAKE D3564-7 FROM D3564-7F)

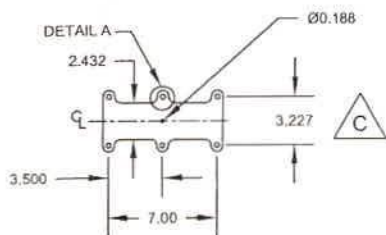


**D3564-11 BENDING DETAIL**  
(MAKE FROM D3564-1F)

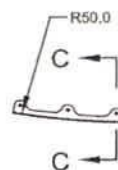
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07.09.04

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DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	FILE	SCALE
DE APPR.	PH	WEARSHOE	1:8
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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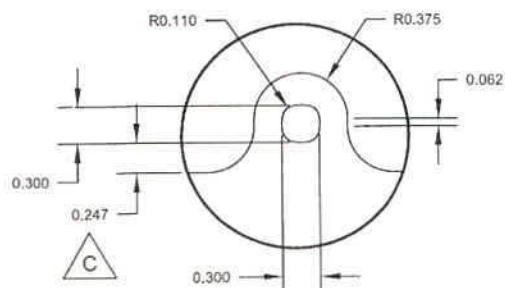




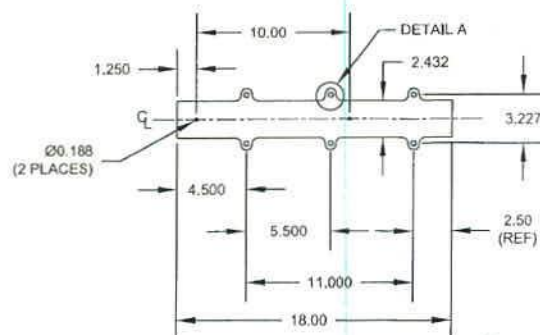
**D3564-13F FLAT PATTERN**



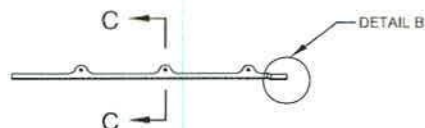
**D3564-13 BENDING DETAIL**  
(MAKE D3564-13 FROM D3564-13F)



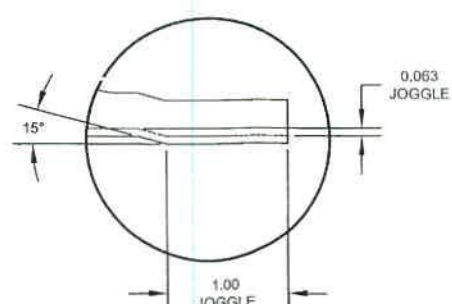
**DETAIL A**  
SCALE 1:1



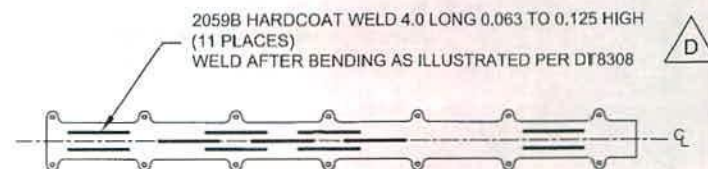
**D3564-15F FLAT PATTERN**



**D3564-15 BENDING DETAIL**  
(MAKE D3564-15 FROM D3564-15F)



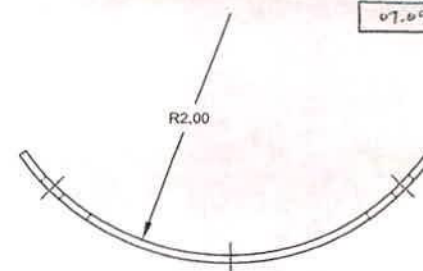
**DETAIL B**  
SCALE 1:1



**DETAIL D**  
(D3564-1/-3/-9/-11 WELDING DETAIL)

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07.07.04



**SECTION C-C**  
SCALE 1:1

DESIGN	PH	<b>DART AEROSPACE LTD</b>	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 3 OF 3
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